

What Is Claimed Is:

1. A method for fastening and aligning at least one sensor, especially in motor vehicles,
  - the sensor having a sensor axis,
  - the sensor is connected to a support via a holding element,
  - and the holding element has a sensor seating surface for the sensor,wherein
  - the holding element is connected to the support
  - the sensor seating surface of the sensor on the holding element is reworked in such a way that, in the case of the installed sensor, the sensor axis is aligned in the nominal direction,
  - the sensor is connected to the holding element at the reworked sensor seating surface.
2. The method as recited in Claim 1, wherein
  - the deviation, present without reworking, of the sensor axis from the nominal direction is ascertained,
  - the sensor seating surface of the sensor on the holding element is reworked based on of the deviation ascertained of the sensor axis from the nominal direction,
3. The method as recited in Claim 1, wherein
  - the support with the holding element connected to it are built into a carrier,
  - the sensor seating surface of the sensor on the holding element is reworked by a reworking device connected to the carrier in such a way that, in the case of the installed sensor, the sensor axis is aligned in the nominal direction.
4. The method as recited in one of the preceding claims, wherein the at least one sensor is at least an ultrasound

sensor and/or at least a light-sensitive sensor and/or at least a video sensor and/or at least a sensor for electromagnetic radiation, especially radar radiation.

5. The method as recited in one of the preceding claims, wherein there is a sensor axis in the direction of the holding element and the support, or opposite thereto.

6. The method as recited in one of the preceding claims, wherein the holding element is connected to the support by an adhesion process, the reworking of the sensor seating surface being able to take place during the hardening of the adhesive in the adhesion process.

7. The method as recited in one of the preceding claims, wherein the reworking of the sensor seating surface takes place by material-removing processing methods, preferably milling, drilling and or laser processing.

8. The method as recited in one of the preceding claims, wherein at least one centering pin receptacle is applied in the correct position at the sensor seating surface, preferably during the reworking of the holding element, and thereby the alignment of the sensor with respect to its rotation about the sensor axis takes place by at least one centering pin applied on the sensor.

9. The method as recited in one of the preceding claims, wherein the holding element has an accommodation for at least a part of the sensor and/or the holding element has a sensor antechamber which are protected from intrusion of chips and/or dirt by the reworking, preferably by a cover element.

10. A device for fastening and aligning at least one sensor, especially in motor vehicles,

- the sensor having a sensor axis,
  - having a holding element that has a sensor seating surface,
- wherein
- the holding element has an accommodation for at least a part of the sensor,
  - the sensor seating surface is able to be reworked,
  - the sensor seating surface determines the position of the sensor axis,
  - and during the reworking of the sensor seating surface for the alignment of the sensor axis to a nominal direction, the accommodation remains unchanged.

11. The device as recited in Claim 10, wherein the at least one sensor is at least one ultrasound sensor and/or at least one light-sensitive sensor and/or at least one video sensor and/or at least one sensor for electromagnetic radiation, especially radar radiation.

12. The device as recited in one of Claims 10 or 11, wherein the holding element is fastened to a support, the holding element demonstrating component part tolerances, the support having a convex, concave and/or a planar surface for the accommodation of the holding element, the support has component part tolerances and/or the support is made of glass, preferably is the windshield of a motor vehicle.

13. The device as recited in Claim 12, wherein there is a sensor axis in the direction of the holding element and of the support, or opposite thereto.

14. The device according to Claim 12 or 13, wherein the support and/or the holding element are partially or completely transparent to the sensor-influencing variables because of the material properties, and/or the transparency to the sensor-

influencing variables is achieved by material-removing processing methods.

15. The device as recited in one of Claims 10 through 14, wherein at least one centering pin receptacle is present on the sensor seating surface, whereby the alignment of the sensor with respect to its rotation about the sensor axis may take place by at least one centering pin applied on the sensor.

16. The device as recited in one of Claims 10 through 15, wherein the holding element has a sensor antechamber, the sensor antechamber being dimensioned in such a way that, after the reworking of the sensor seating surface, the angular coverage of the sensor is not restricted by the walls of the sensor antechamber.

17. The device as recited in Claim 16, wherein, in the case of the installed sensor, a sealing ring between the holding element and the sensor seals the accommodation and/or the sensor antechamber of the holding element from the surroundings, the sealing ring being dimensioned in such a way that it can accommodate the tilting of the sensor after the reworking.